

Work Order ID 86667

86667

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July-06-12 11:19:11 AM

Item ID: D1049 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 7/06/12 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: *P* Date: *12-07-12* Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D1049	Rev A								
100		0.00							
100	SHEAR								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blanks: 2.000" long								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per folio FA217 & Dwg D1049 2-Deburr								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

cut 12/07/26 20 *x*

DAS 14 12/07/27 26 *x*

DAS 14 12/07/27 20 *x*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		DAS 13 9-89 12/17/27		20	2		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				20	76	12-7-30	
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 1:50 OVEN TEMPERATURE: 3200 F FINISH TIME: 2:20	0.00 0.00				20	X		12/07/31

12/17/279

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

20

20

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

160

0.00

20x 6 Al n(07/30

0.00

170

0.00

Packaging

20x _____ E/S 12/8/01

0.00

180

0.00

Quality Control

12/8/17
ML5 12/08/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 86667

Parent Item: D1049

Parent Item Name: Saddle

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevC02.04.10Re-formatNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.250 6061-T6 Bar .750 x .250		Purchased	No			100	f	42.6900	0.1666	3.507368			

Location

Loc Qty

Loc Code

MAT003

42.69

120129

42.69

3.51 , on 12/07/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

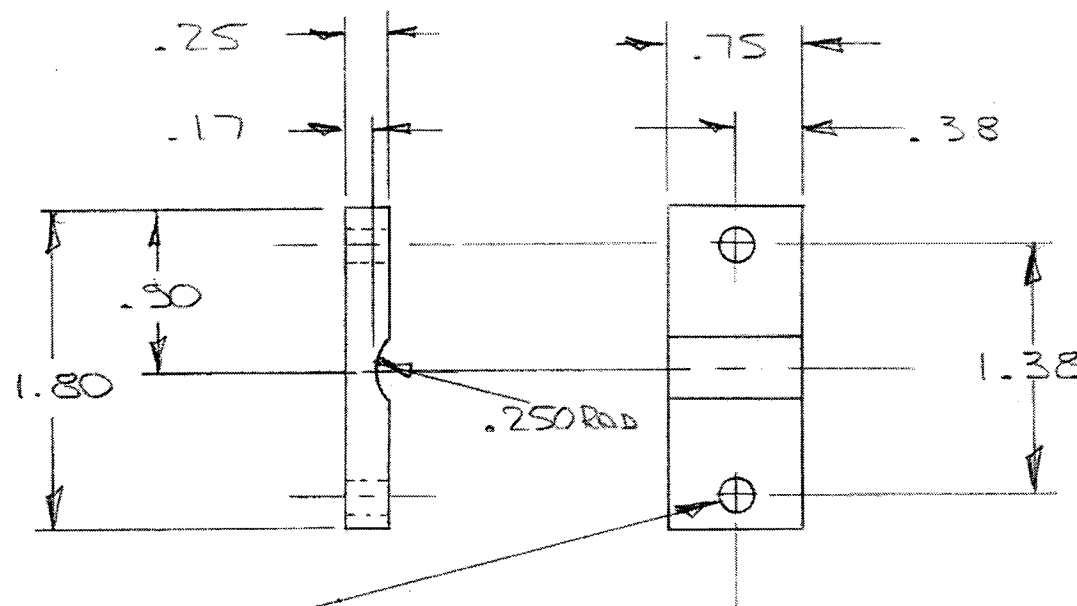
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
97/07/02 Bw



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 866667

12/12-07-6

.203 DIA.
TYP

MATERIAL : 5052-H32

FINISH : POWDER COAT



REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC./VENDOR	
DRAWN				BASIC CODE		DIA. DASH NO.		CONTRACT NO.		DART		DART AERO ACCESSORIES INC.		VANCOUVER CANADA	
APPROVED				D-ORANGE		W-HEAD NEAR SIDE		DRAWN		DATE					
				E-COUNTERSINK		P-HEAD FAR SIDE		DESIGN		14/12					
DESCRIPTION OF CHANGE		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES		LENGTH DASH NO.		STRESS		TITLE		SADDLE			
		GENERAL		LIMITS		W-SPOTWELD		CHECKED		CODE		DNG NO.		REV.	
		1. DIMENSIONS ARE IN INCHES		1. TOLERANCES -- .001 & .010		B-HEAD 204 DEAD		CLIENT		SCALE		1:1		SHT OF	
		2. SURFACE ROUGHNESS .015 MAX		2. ANGLES .010								D1049			
		3. REMOVE SHARP EDGES .015 MAX		3. PARALLELISM .0025											
		4. THREADS PER INCH - 5 - 7147		4. ECCENTRICITY .005 MAX											
		5. HOLES PER AND 10247		5. SYMMETRY ABOUT ALL DIA/C CENTRE LINES .005											
REPORT ALL DISCREPANCIES - DO NOT SCALE															